

Date: Wednesday, 11/03/2009 9:53:20 AM
 User: Chantal Laviole

Process Sheet

Split-2

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46412 -2
 Estimate Number : 10035
 P.O. Number :
 This Issue : 11/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : PURCHASED PARTS
 Previous Run : 42991
 Written By :
 Checked & Approved By : C209/03/11
 Comment : Est. A: 01.05.04 New Issue LEC

Drawing Name : SADDLE BILLET
 Part Number : D6101007
 Drawing Number : D6101 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 18/09/2009 Qty: 350 Um: 300 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 8393

a) Description: Alluminum billet

b) 7.750" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.750" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

C209/03/13
(300)

2.0 D6101007P 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 300.0000 Each(s)
 7075-T7351 8.25X7.75X2.5

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

50 C-9/6/9
28 09/06/02

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

S09/06/10 (208)

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Drawing Name: SADDLE BILLET

Job Number: 46412

Part Number: D6101007

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Machinist MF 09-06-15

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/15

Job Completion



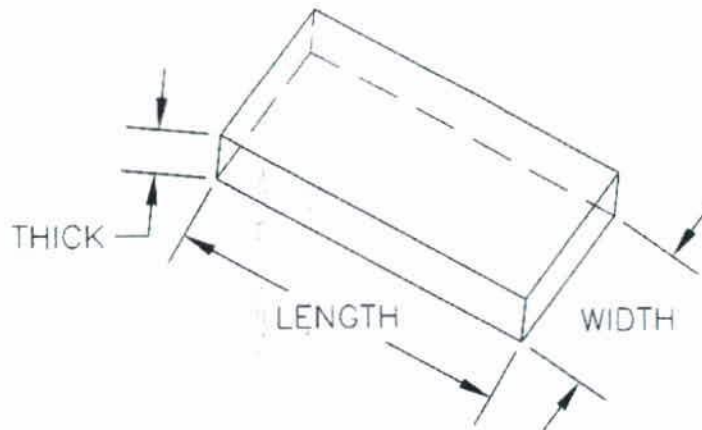
MF 09-06-15



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>AS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *A*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46412

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

u/o 46412

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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**Castle Metals®**

A. M. Castle & Co.

BORDEREAU DE MARCHANDISES

Page 1 of 1

No de Formulaire d'Emballage / Pack Slip No:2822042

Expédié de / Ship From:		Vendu à / Sold To:		Expédié à / Ship To:		Livré à / Deliver To:	
Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date d'expédition / Date Shipped	F.O.B.	Modalités de transport / Freight Terms		Transporteur / Carrier		N° du Bon de connaissance / BOL No	N° de livraison / Delivery No
08-JUN-09	ORIGIN	Prepaid		LOCAL_FLEET		11845-10	2822042

Détails d'expédition / Shipment Details	Destination finale / Final Destination Branch - MON
---	---

N° de commande / Order No	N° de ligne Line No	N° d'article / Item No	Description				
197018	2	6879.MO	2.5000.PL.7075.T7351.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 8.25 IN () X 7.75 IN ()				
N° de bon de commande / Purchase Order No		Nbre de pièces / Part Number	Qté commandée / Ordered Qty	Qté Facturée / Invoice Qty	Solde à livrer / Backorder Qty		
8393			50 PCS	50 PCS			
Détails / Details							
Usine / Mill		No de coulée / Heat Number	Code méc / Mech Id	Pièces / PCS	Largeur (Pouce)/ Width (IN)	Longueur (Pouce)/ Length (IN)	Qté expédiée/ Shipped Qty (LBS)
		407251		50			807.36

Ces marchandises/technologies sont sujettes aux règlements de l'Export Administration et du département d'Etat des États-Unis. Si elles ont été/sont exportées, elles doivent se conformer à ces règlements. Toute modification du contrat de transport contraire aux lois des États-Unis est interdite.

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

Nous certifions par la présente que le matériel couvert par cette certification est conforme aux spécifications susmentionnées et aux exigences applicables pour le matériel, y compris toute spécification faisant partie de la description. Les rapports d'essai sont archivés pour fins de consultation. Toute requête concernant du matériel défectueux sera rejetée à moins qu'elle ne soit faite par écrit à A. M. Castle & Co. dans les 60 jours suivant la livraison. Le matériel coupé sur mesure ou coupé par le client ne peut être retourné pour crédit.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Ce matériel a été reçu et inspecté par
This material has been received and inspected by:

Date:

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material meet the composition limits and had the mechanical properties shown on the face of this sheet.

Walden Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

993937 0
Ship Date B.I. No. Invoice No. Alcoa No. Item Page
2009-01-10 3286081 00000 1000062304-1
P.O. No./Govt Contract No. Customer Alcoa Item Mfg Order
01-16542 CASTLE A M G041005634R08 DS-62304-1

Ship To: A M CASTLE & COMPANY
3400 NORTH WOLF ROAD
BAY #6
FRANKLIN PARK 60131 IL

Item Description
2.5 IN TK (+.0750 -.0750) X 48.5 IN W (+.3125 -
0.000) X 144.5 IN LN (+.5 -.0) CAT D 164168 (M) A/T 7075-
T7351 RECTANGLE MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES,
SAMED IAC 6879, EXC MRK A97075-60 REV 22 AMS-QQ-A-250/12 IS 2007 AMS-
STD-2154 EXC MRK AMS4078 REV G EXC MRK ASTM209
REV 07 ASTM5594 REV 06 BSS7055 REV A
EXC MRK MMS159 REV N PS21211 REV K ((MARKED))
KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-
25 % US1 CL A 3 MM CQR 0137890 REV 17 CUST REQ 08-11-
04 *** W/E 09-01-17 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Ser1
1	709656	407251	3545	2	PC	

509/06/10

Notes for CQR: 0137890.17

PRODUCT PRODUCED TO THE REQUIREMENTS OF ASTM2375 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF ASTM2375.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12P. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.
Exception to Spec A97075-60 ; Raven: 22 Issue: Letter dated 2007-05-14 from AHSRN, DENNIS T to FLATTER, BARB .

CQR: 0137890.17 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
		KSI	KSI	PCT
T7351	Long Transv.	Max	63.9	
		Min	66.0	6
T7351	Elec. Cond. (2C) & MIN		38.0	PCT

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
	Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05
	Min			1.2		2.1	0.18	5.1		0.15
Alloy 7075										REMAIN

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per:

Malcolm Murphy
Director of Manufacturing Development Works

Kanton P. Young
Quality Assurance Manager

Ship From: RIVERDALE, IA.

993937	0				
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item	Page 2
2009-01-10	3286081	00000	1000062304-1		
P.O. No./Govt Contract No.	Customer	Alcoa Item	Mfg Order		
01-16542	CASTLE A M	0041005634R08	DS-62304-1		

CQR: 0137890.17 -Specification Limits (cont.)

Lot: 407251 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. -> Test	UTS KSI	TYS KSI	EL40 PCT
T7351	Long Transv.	3	69.8	58.3	10.3
			69.8	58.2	10.4
			69.8	57.8	10.2

T7351 Elect Cond %IACS 40.4 40.7 40.5 PCT

Cast Number	Chemical - OES	SI	FB	CU	MN	MG	CR	ZN	TI
H9127044	Actuals	0.06	0.29	1.6	0.02	2.5	0.19	5.7	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

CASTLE METALS CORP
DATE RCVD 11/14/09
IAC 6879
APPROVED BY [Signature]

AM CASTLE METALS

B474568927 P.018